

Agglomerated Fluxes And Wires For Submerged Arc Welding

SUPERMELT - I

AWS Classification (AWS - SFA - A 5.17) - F-6AO-EL8

HARDNESS (on two layer deposits) BHN

APPLICATIONS

General purpose fabrication flux suitable for single or multiple pass welding of carbon and low alloy steel such as IS-2062, IS-2002, A-515 Gr.60 etc. Also suitable for sheet metal fabrication.

CHEMICAL COMPOSITION (%)

C	Mn	Si	S	P	Cr	Mo	Cu
0.10 Max.	1.0-1.60 Max.	0.55 Max	0.03	0.03 Max.	19.5-22.0	–	--

MECHANICAL PROPERTIES

Y.S. MPa (Min)	U.T.S. MPa	ELONG. %(Min)	IMPACT Joule (Min)
330.0	430-560	22.0	27-J at - 20 ⁰ c

